

Ship latest Thurs 12/08

# Work Order ID 57170

March 24, 2010 12:21:59 PM



Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 24/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten initials*

Date: 10-3-24 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

Convert to I.T DSI 9473

100

Weld per dwg A/R S.S. rod Batch: *M114649* 0.00



Large Fab

Memo

0.00

Large Fab

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512  
2-Cut (4) D2236 From D3166-3  
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305  
4-Weld as per Dwg D2512 using Welding Jig DT 9436  
Deburr as required

\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

5 - Drill holes in D2512-1 per DSI 9473

*PD 10.08.18*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*KE 10.08.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00				1			1003-18
130 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo 1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat	0.00							ml 10 08 18 (1)

1ST COAT:

START TIME: 2:15

OVEN TEMPERATURE: 400°

FINISH TIME: 2:45

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: 115008

10 08 19 ①

150

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

10/08/19

1 0

160

0.00



Identify as per dwg & Stock Location: C-A

Packaging

Memo

0.00

Packaging

u/o  
61293

10/08/19 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/19 AJ

CZ1018119

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# Picklist Print

March 24, 2010 12:22:03 PM

Page 1

Work Order ID: 57170

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 24/03/2010

Required Date: 31/03/2010

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF  
IPP Rev:N 06.04.05 Added level21 EC  
IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2012-117



Clevis

Manufactured No 100 Each 41.0000 2.0000

Warehouse  
Location  
Main Warehouse  
WA  
31101  
52498  
55729

Loc Qty  
41  
2  
9  
30

Loc Code

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
NOT USED, PLEASE MARK N/A \*\*\*

D2232-1



Basket Hinge

Manufactured No 100 Each 40.0000 2.0000

Warehouse  
Location  
Main Warehouse  
WA  
48230  
55791

Loc Qty  
40  
2  
38

Loc Code

D2327-1



Spacer Bushing

Manufactured No 100 Each 27.0000 2.0000

Warehouse  
Location  
Main Warehouse  
WA  
52832  
54658

Loc Qty  
27  
7  
20

Loc Code

PD 10.08.09

PD 10.08.09

①

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 IPP Rev:N 06.04.05 Added level21 EC  
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2506 Manufactured No 100 Each 6.0000 1.0000



Label Plate



B60272 -> ① PD 10.08.09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 6

44275 1

55700 5

D2581 Manufactured No 100 Each 35.0000 2.0000



Mounting Bracket



B60193 -> ② PD 10.08.09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 35

46086 2

48428 1

50872 1

51120 2

51745 2

55918 27

March 24, 2010 12:22:03 PM

Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No 100 Each 16.8103 1.0000



Basket Hoop

100810

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

WA	16.81031447
48429	5
52058	1.4474E-05
55697	5.8103
56426	6

M304EX0.75-16F

Purchased

No

100 sf

M 59266 → 1081.944 18.9474



Expanded Metal Flat SS

~~111482~~ 75  
 SAD 10-08-12

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

MAT	1081.944806
111956	0.000017
112147	9.4736E-06
112949	19.84438
113205	0.0093
113497	0.1449
113555	649.5873
113904	92.3589
114212	320

M115401

M114853

16.9474

2.00

March 24, 2010 12:22:03 PM

Shop Packet Print

Page 3

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IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

638.1112 45.8741



304 SQ Tube .75x.75x.065W

4115274

PD 10.03.10

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

WA

638.1111759

112398

0.0000047

113082

0.00419

113245

8.40038421

113683

0.30855

113836

0.000047

113956

29.398

114137

600

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Shop Packet Print

Page 4

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# **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

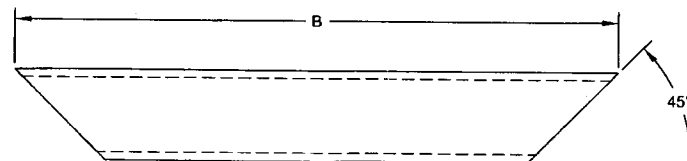
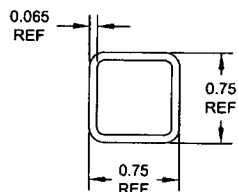
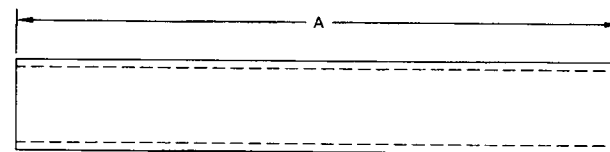
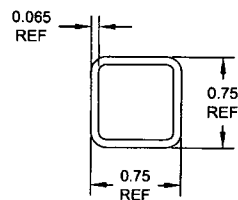
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 57170

*Bj10-3-24*

**RELEASED**  
*08-06-21/17*



## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

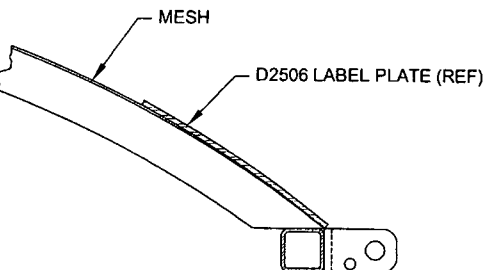
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**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY

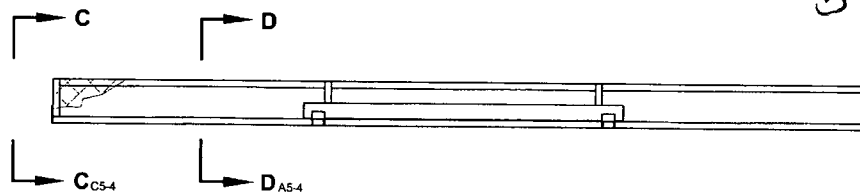
D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



**RELEASED**  
08.05.21/11

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

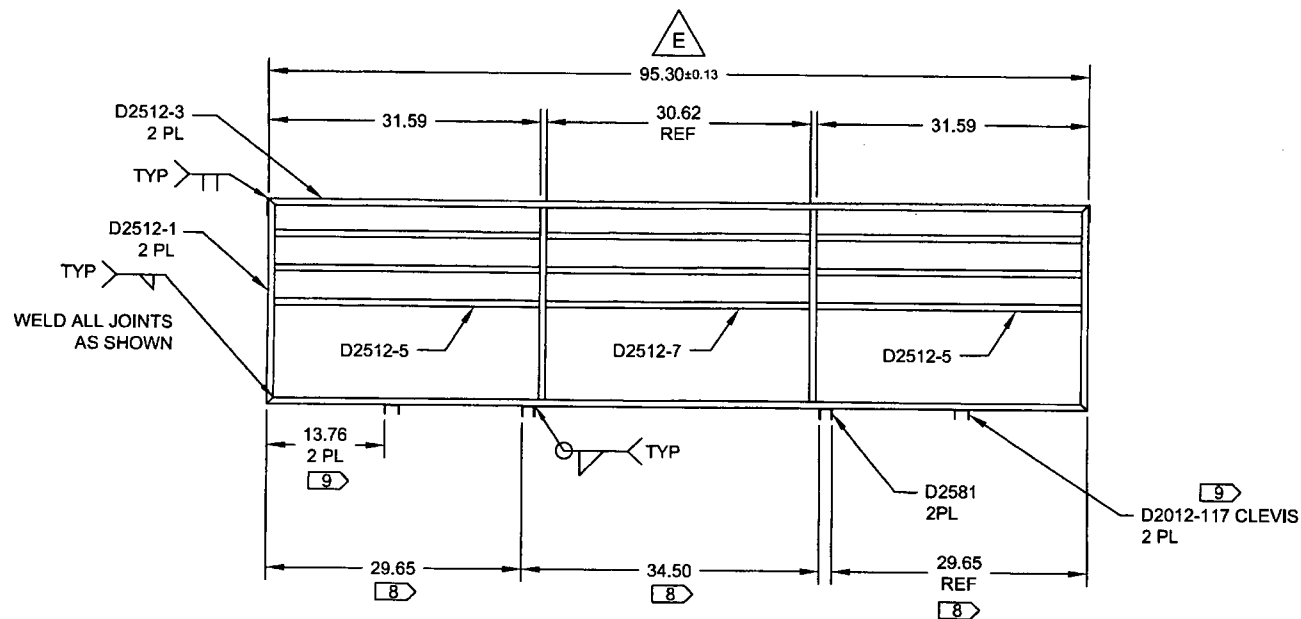
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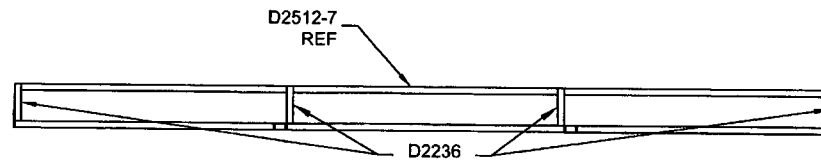
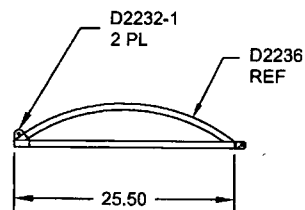
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**DETAIL B** <sub>C3-2</sub>  
FRAMEWORK ONLY SHOWN FOR CLARITY



57170

**RELEASED**  
08.06.17

- NOTES:**
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A
  - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
  - 9) FOR D130-701-D41 ONLY

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	10	D2512	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	BASKET LID ASSEMBLY (350/212)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

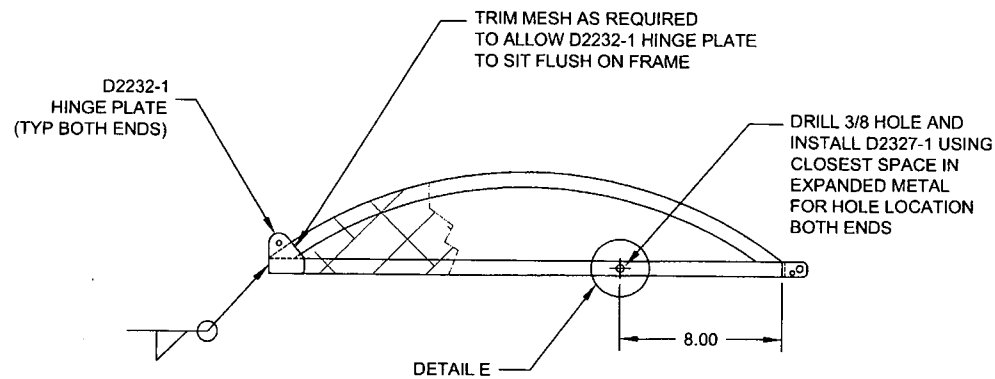
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

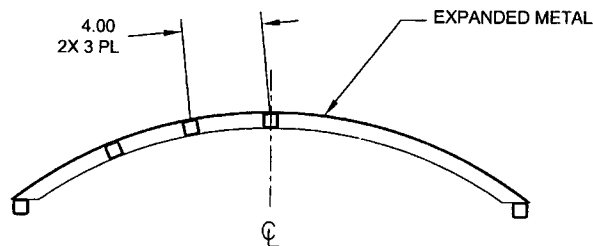
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

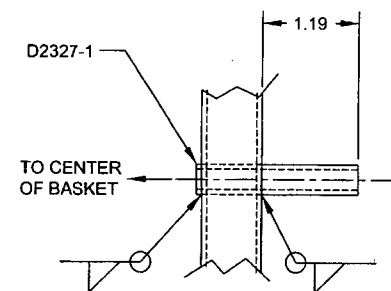
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

57170

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MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET*)
2		X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3	GAS SPRING STUD (LID)
6	2	1	1	D3953-5	GAS SPRING STUD (BASE)
7	2	1	1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9	GAS SPRING WASHER
9	2	1	1	D3953-11	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15	GAS SPRING BRACKET
12		1		D3953-17	GAS SPRING SPACER
13	2	1	1	D3969-1	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
23	4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

**\*NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE LID OPENER PRE-INSTALLED USE THE FOLLOWING NUMBERS:




D350-607-041 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-041A  
D350-607-043 BASKET WITH AUTOMATIC LID OPENER INSTALLED= D350-607-043A  
D350-607-045 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-045A  
D350-607-047 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-047A

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BRANCH  
DAO # 01-O-01

**APPROVED**

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.11.11  
CERT. NO.: SH94-14  
ISSUE NO.: 4

C	SHEET 1 PL, -143 INSTL, ITEM 6 QTY WAS 2, ITEM 7 WAS 0.	AJS	09.11.11
B	SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR) INSTALLATIONS RENAMED.	AJS	09.11.06
A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM AS FOLLOWS:

### **D350-607-141 AUTOMATIC LID OPENER INSTALLATION**

**NOTE:** ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

**NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.
- 8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.11.11  
CERT. NO.: SH94-14  
ISSUE NO.: 4

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 2 OF 8
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DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-143 AUTOMATIC LID OPENER INSTALLATION**

**NOTE:** THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.




- 1) REMOVE THE D2332-041 PROP ARM.
  - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
  - 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
  - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
  - 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.
- NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.
- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9473	SHEET 3 OF 8
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FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-145 AUTOMATIC LID OPENER INSTALLATION**

**NOTE:** THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

**NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

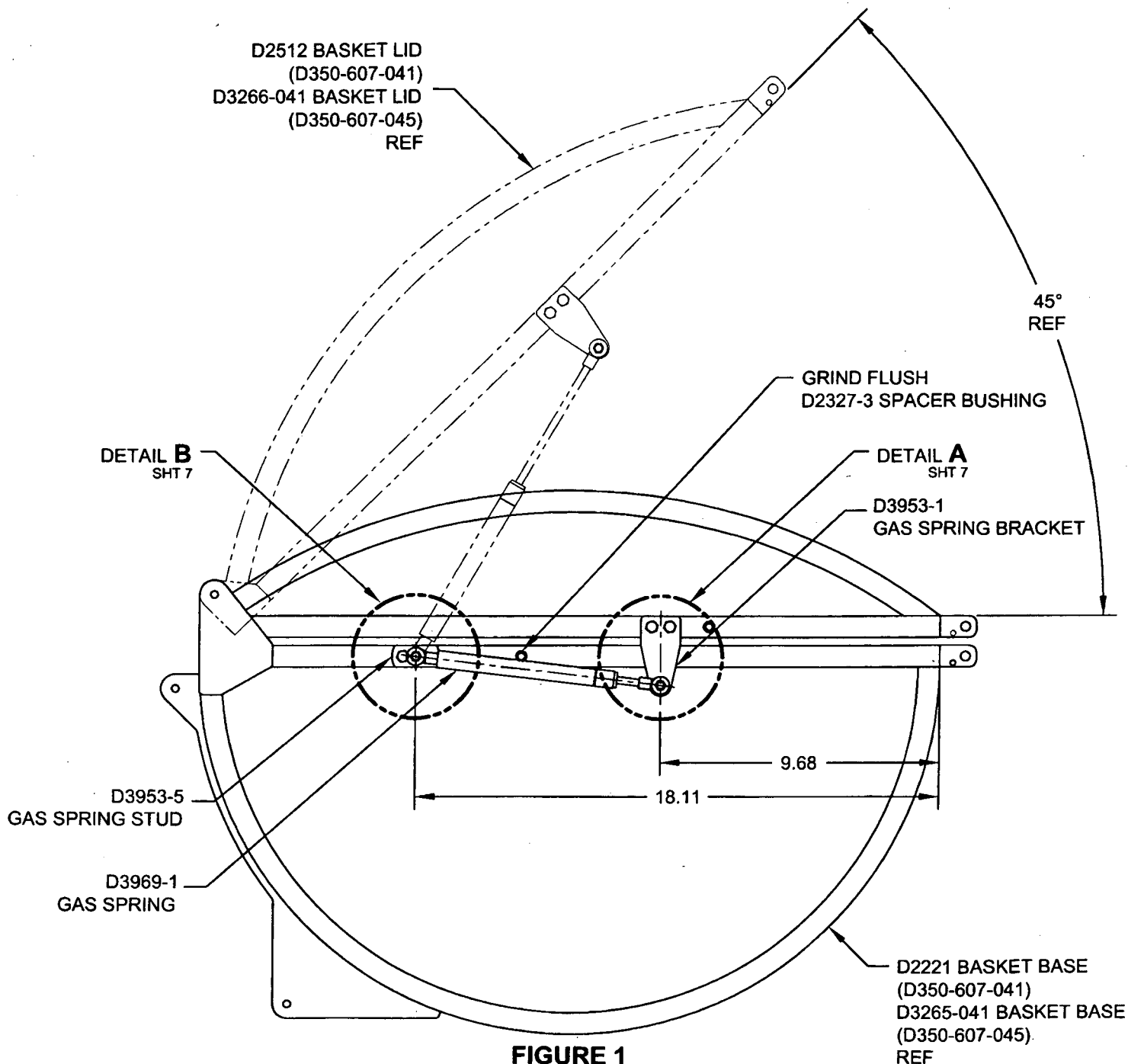
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BY:   
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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**FIGURE 1**

**D350-607-141 AUTOMATIC LID OPENER INSTALLATION**

(BOTH ENDS)

**D350-607-145 AUTOMATIC LID OPENER INSTALLATION**

(1 END ONLY)

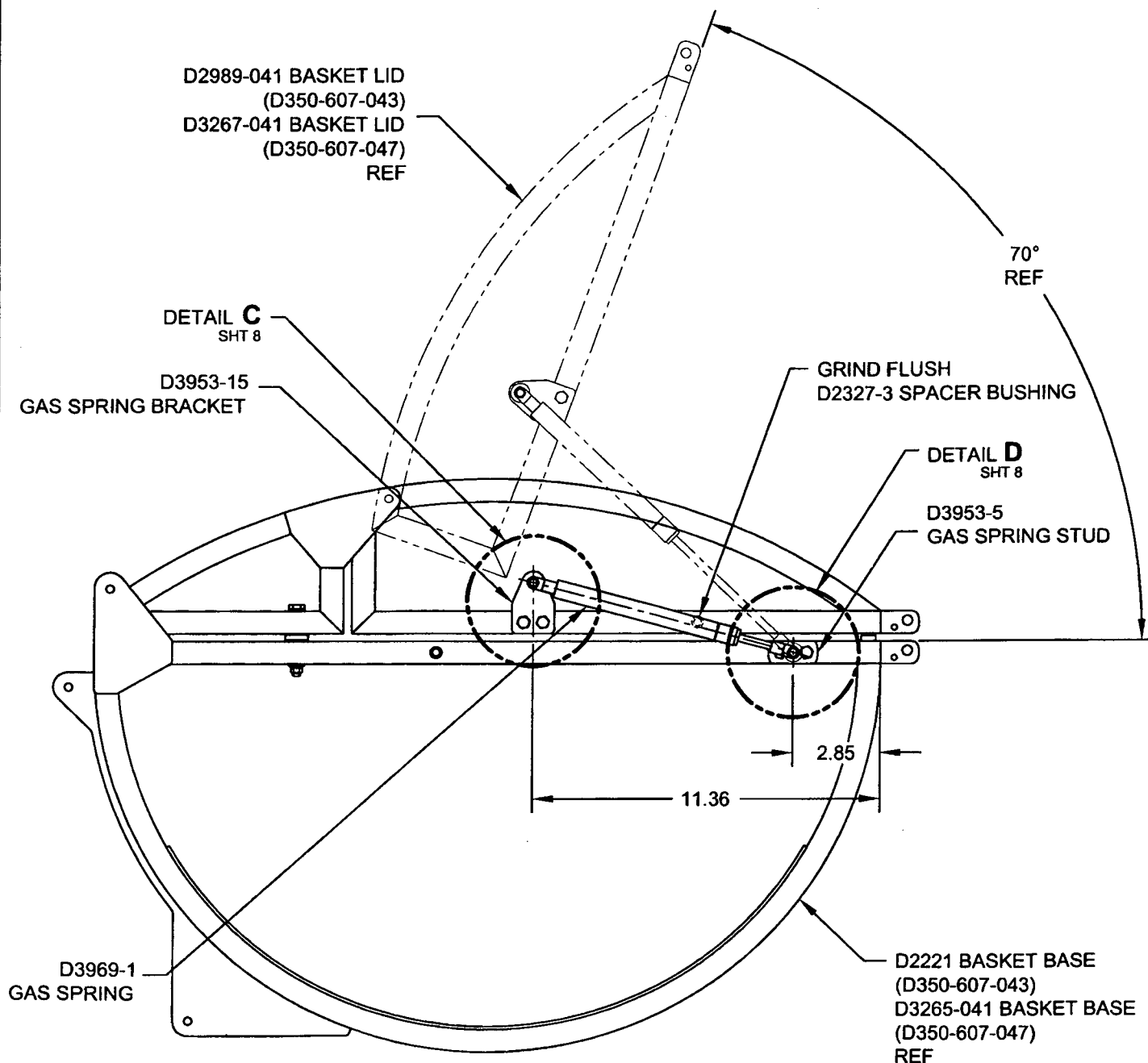
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BY: *[Signature]*  
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL	NTS
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**FIGURE 2**

**D350-607-143 AUTOMATIC LID OPENER INSTALLATION**

(1 END ONLY)

*WLB  
5/11/70*

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CERT. NO.: SH94-14  
ISSUE NO.: 4

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL	NTS
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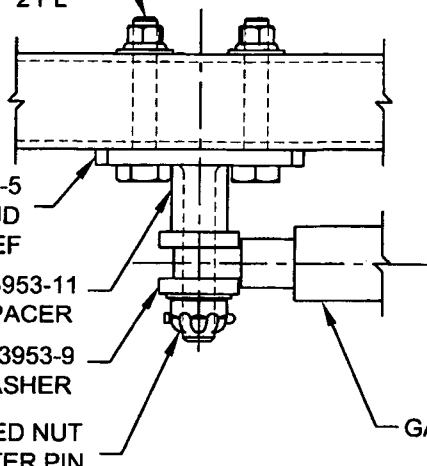
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NAS1149C0332R WASHER  
MS21043-3 NUT  
2 PL

D3953-5  
GAS SPRING STUD  
REF

D3953-11  
GAS SPRING SPACER

D3953-9  
GAS SPRING WASHER

AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432R WASHER



**VIEW F-F**

AN3C16A BOLT  
NAS1149C0332R WASHER  
MS21043-3 NUT  
2 PL

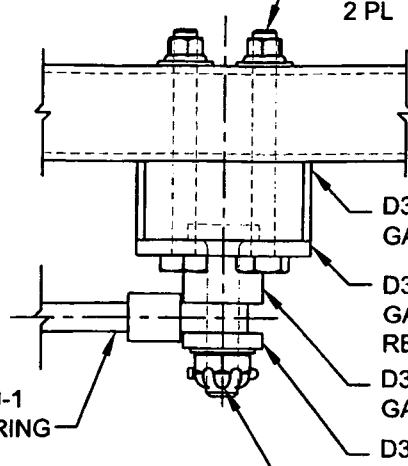
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GAS SPRING SPACER

D3953-1  
GAS SPRING BRACKET  
REF

D3953-7  
GAS SPRING SPACER

D3953-9  
GAS SPRING WASHER

D3953-3 GAS SPRING STUD  
AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432R WASHER

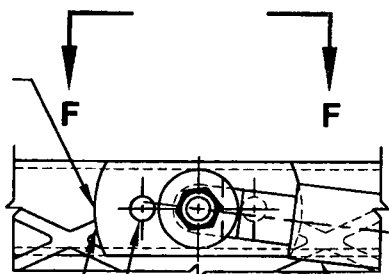


**VIEW E-E**

D3953-5  
GAS SPRING STUD  
REF

TRIM MESH LOCALLY  
AS REQUIRED

TRANSFER MARK AND  
DRILL Ø0.194 THRU  
2 PL



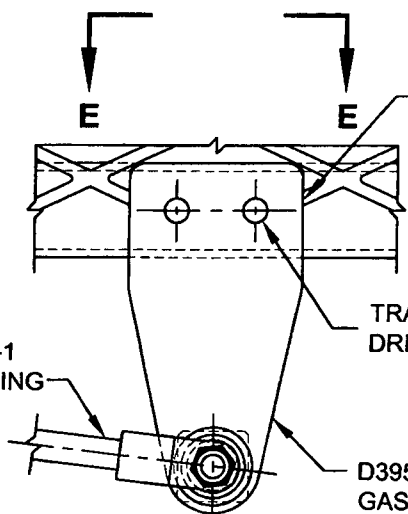
**DETAIL B**

E

TRIM MESH LOCALLY  
AS REQUIRED

TRANSFER MARK AND  
DRILL Ø0.194 THRU

D3953-1  
GAS SPRING BRACKET  
REF



**DETAIL A**

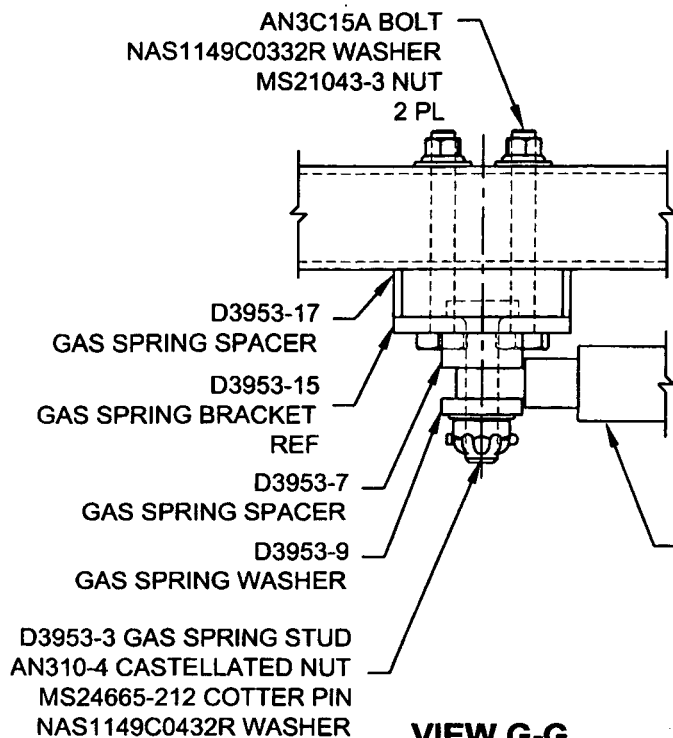
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

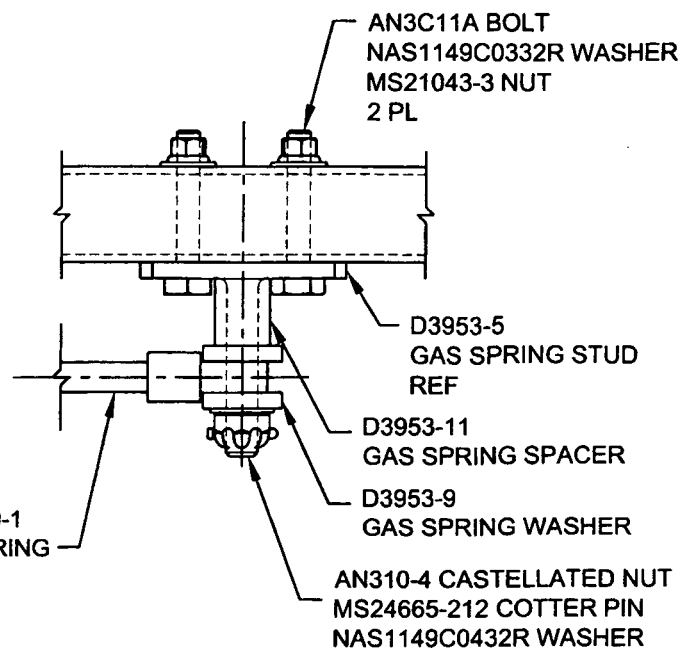
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.11.11  
CERT. NO.: SH94-14  
ISSUE NO.: 4

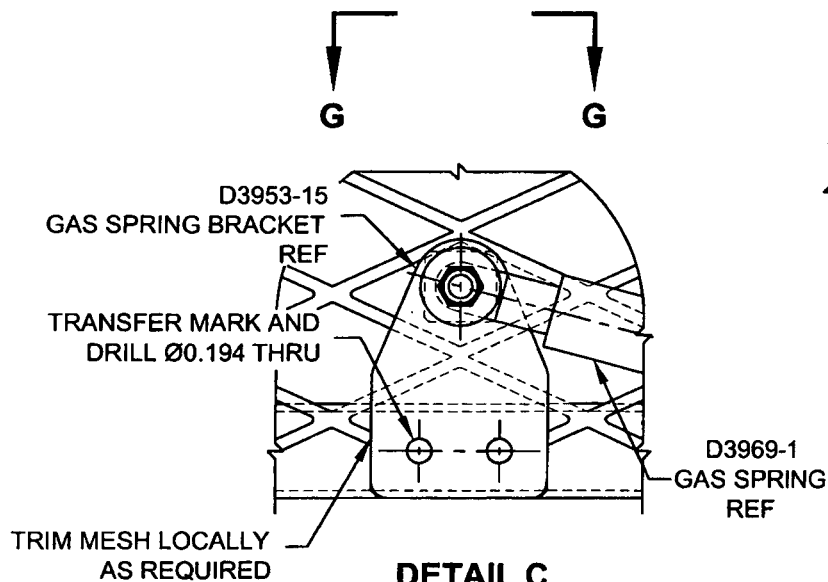
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 7 OF 8
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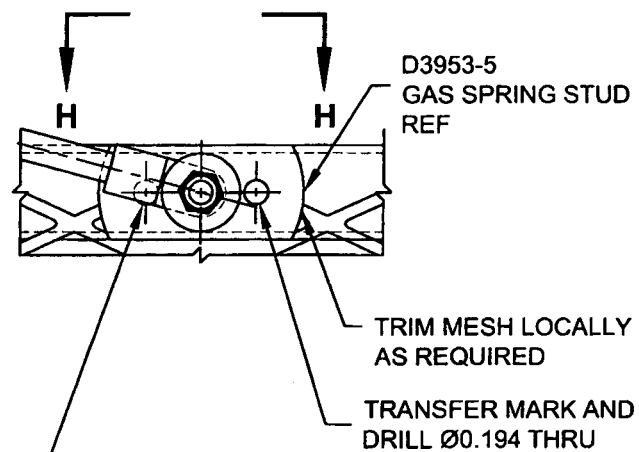
**VIEW G-G**



**VIEW H-H**



**DETAIL C**






**DETAIL D**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.11.11  
CERT. NO.: SH94-14  
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